

Date: Friday, 24/10/2008 3:32:07 PM  
User: Julie Dawson

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	BACK LEG FITTING		
Job Number	42958			Part Number	D37641		
Estimate Number	13293			Drawing Number	D3764 REV B		
P.O. Number				Project Number	N/A		
This Issue	24/10/2008	S.O. No.		Drawing Revision	B		
Prsh Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	03/11/2008	Qty:	30
Previous Run	40970			Um:	Each		
Written By	<u>JULIE DAWSON 10/27</u>						
Checked & Approved By							
Comment	Est Rev:A New Issue 08-05-01 JLM Verified By:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X02000	6061-T6 Bar 1.50 x 2.00	
		Comment: Qty.: 0.2625 f(s)/Unit Total : 7.8750 f(s) 6061-T6 Bar 1.5 x 2.0 M108877X1 Batch: M18147	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blank 2.95" long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1- Mill as per Folio FA741 Rev: <u>B</u> & Dwg D3764Rev: <u>B</u>	PTO
		2-Deburr per dwg D3764	H.A 08/10/30
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	H.A 08/10/30
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.F. 08/11/01 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3764-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08.11.04

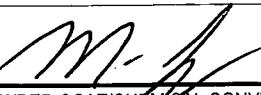
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.10.31	3.0	<p>14 parts have the hole slightly enlarged on 1 side only on the Ø.323, +0.006; up to 0.004" over tolerance.</p> <p>R.C: Material build up in the drill flutes.</p>	J Desnull	parts acceptable in the ASS'y	H.A 08/10/31	/6.8.11.04.	/05/11/12	/18.10.31

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BACK LEG FITTING
Job Number: 42958		Part Number: D37641
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">30X</span>
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		 08/11/03
7.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">30X</span>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		08-11-03
8.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 250		AS 08/11/03 <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">30</span>
9.0	QC21 	FINAL INSPECTION/W/O RELEASE  08/11/04 <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">30</span>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		MF 08-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

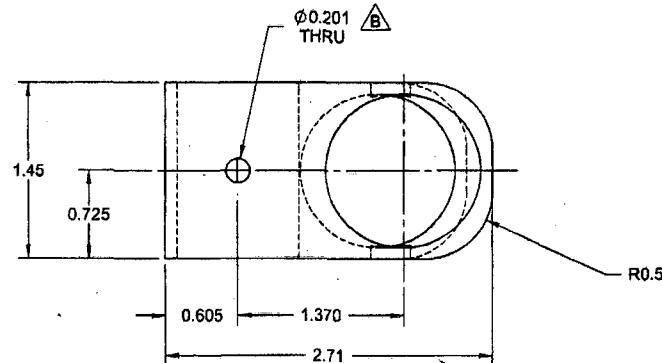
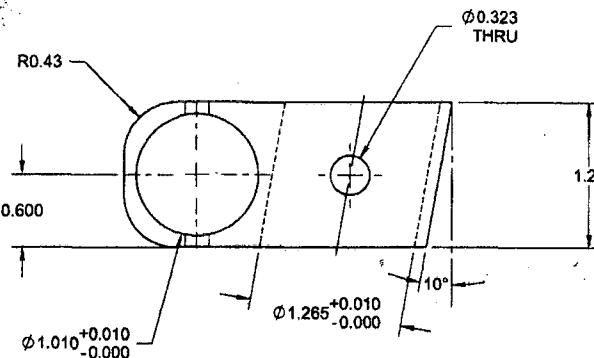
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

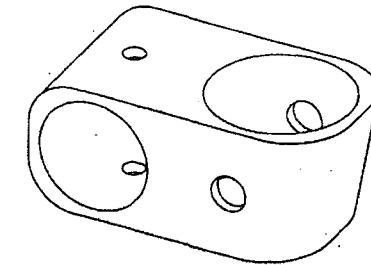
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

w/o 42958



**D3764-1 BACK LEG FITTING**



10/07/10 MP

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	DRAWING NO.	REV. B
MFG. APPR.	✓	D3764	SHEET 1 OF 1
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	BACK LEG FITTING	NTS
DATE	08.06.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS EXCLUDED FROM THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- A NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.13 lbs

DART AEROSPACE LTD	Work Order:	612958
Description: Back Leg Fitting	Part Number:	D3764-1
Inspection Dwg: D3764      Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

<b>Measured by:</b>	<b>J. A.</b>	<b>Audited by:</b>	<b>J. F.</b>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	<b>08/10/30</b>	<b>Date:</b>	<b>08/11/01</b>	<b>Date:</b>	<b>N/A</b>

Rev	Date	Change	Revised by,	Approved
A	08.07.24	New Issue	KJ/DD	 